

June-29-12 7:57:42 AM

86447

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Approvals: **Process Plan:**  **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4422	A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

Chemical conversion

Qc 7

120

Identify as per dwg & Stock Location: 084

0.00

120

Packaging

Memo

0.00

Packaging

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Item ID: D4422-3

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 6/29/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/29/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/30
MRE
12-06-29

Picklist Print

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Work Order ID: 86447

Parent Item: D4422-3

Parent Item Name: Shim

Start Date: 6/29/12

Required Date: 6/29/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

505.6368

0.2443158

6061-T6 .063 Sheet

⑩ FB 12-06-29

Location

Loc Qty

Loc Code

MAT021

121578

505.6368320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

15.86

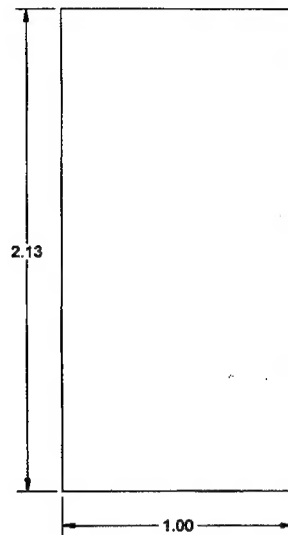
120866

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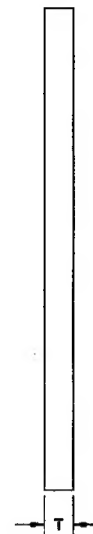
121805

302.264632

0.2443158



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T88
D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

RELEASED
2011-07-06

A		NEW ISSUE		MB		11.06.22	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A			
DRAWN				SHEET 1 OF 1			
CHECKED		DRAWING NO.		REV. A			
MFG. APPR.		D4422		SCALE			
APPROVED		TITLE		NTS			
DE APPR.		SHIM		NTS			
DATE		11.06.22		COPYRIGHT © 2011 BY DART AEROSPACE LTD			
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